

Date: Tuesday, 05/05/2009 3:37:55 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 212/205 HIGH FED X-TUBE ASSEMBLY
<b>Job Number</b>	: 47753		
<b>Estimate Number</b>	: 10254		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D212664101
<b>This Issue</b>	: 05/05/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D212-664-141 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 47752	<b>Drawing Revision</b>	: C
	<b>Type</b>	<b>Material</b>	:
	: CROSSTUBES	<b>Due Date</b>	: 25/05/2009
<b>Written By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b>	: <u>Jul 09 05 05</u>		
<b>Comment</b>	: Est Rev:E 04.02.16 Reformat KJ/DS		
	: Est Rev:F 06-03-29 Remove Coments on Pick List JLM		
	: Est Rev:G 07-04-30 As per Rev C JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for JLD 09/05/13*

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

*09/05/14*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D212664101TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *8-47267*

*MB 09-05-06 ①*

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



*MB*

*09-05-06*



*②*

**Comment:** BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------

**Comment:** DIMENSIONAL CHECK OF X-TUBES

*09/05/06 ②*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 05/05/2009 3:37:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47753

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

BT  
0905-06

- AWM 9-5-6

BT 09-05-06

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



AWM 9-5-6



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/06

9.0 OUTSIDE SERV.11 OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 8757

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C209105107 (1)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



C209105107 (1)



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

11.0 QC5 INSPECT WORK TO CURRENT STEP



ml 09 05 08



(1)

Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47753

Part Number: D212664101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 7:00

Finish Time: 8:46

PAINT:

Start Time: 12:54

Finish Time: 1:50

ml 09-05-10 (1)

13.0	QC14	INSPECT SPRAY PAINT
------	------	---------------------



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

IT 09-05-12

14.0	D28931	2.75 Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support 42440

ml 09-05-12

15.0	D3595063450	RUBBER CUSHION
------	-------------	----------------



Comment: Qty.: 4.2000 Each(s)/Unit Total : 4.2000 Each(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch: 43210

ml 09-05-12

16.0	MS2192025	Clamp(per MIL-DTL-8783C)
------	-----------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25 Clamp 109955

ml 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47753

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

ml  
09.05.12 (1)

2- Install supports with magnobond as per QSI 015. Adhere for 12 Hrs

A/R 6398 Magnobond

Batch: 111249

Expiry Date: 22/2010

3- Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 09.05.13 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



09.05.13 (1)

Comment: INSPECT WORK TO CURRENT STEP

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

20.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: 1345182

1342448

9/5/13

sf

21.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

9/5/13

sf

22.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M110382

9/5/13

sf

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47753

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD616

Washer



9/6/13



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: 1111193

SC

24.0

MS21042L6

Nut



9/6/13



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: 1110002

SD

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/05/14 @

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

E 09/02/14 @

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14 @

Job Completion



MF  
09-05-14

B47753 D212-664-101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

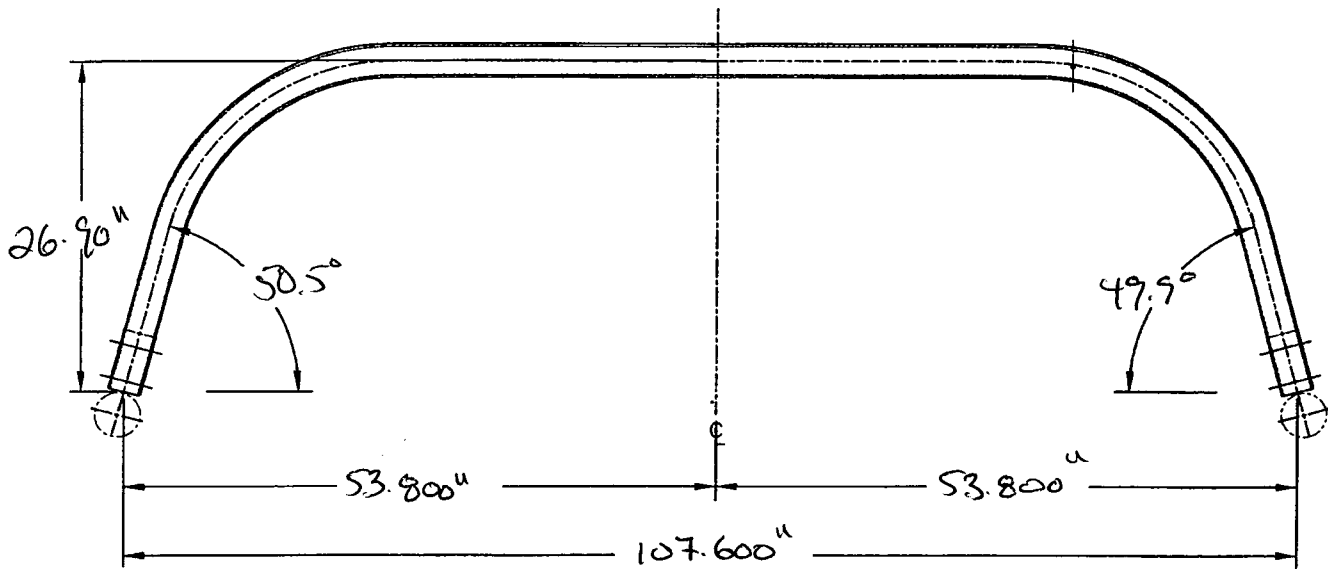
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47753
<b>Description:</b> Crosstube High Fwd (205/212/412)		<b>Part Number:</b> D212-664-101
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	S
Date	09/05/06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	

**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>Q</b>	APPROVED <b>#</b>	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

**RELEASED**07.04.24 **#**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

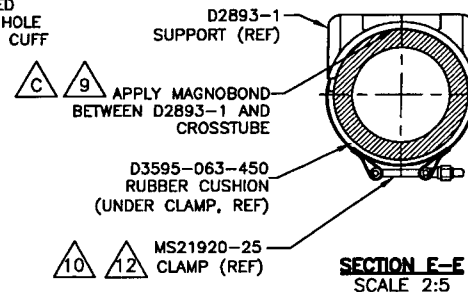
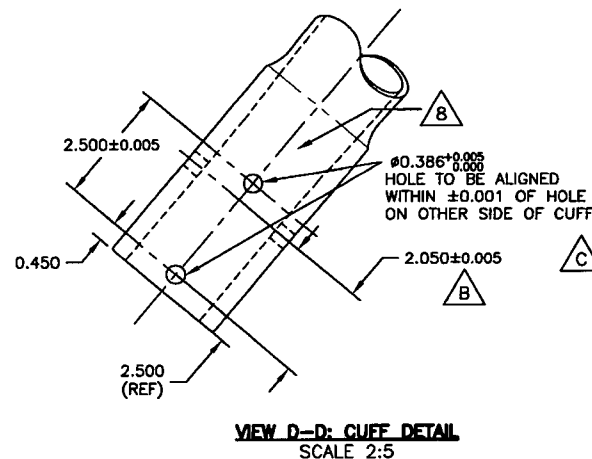
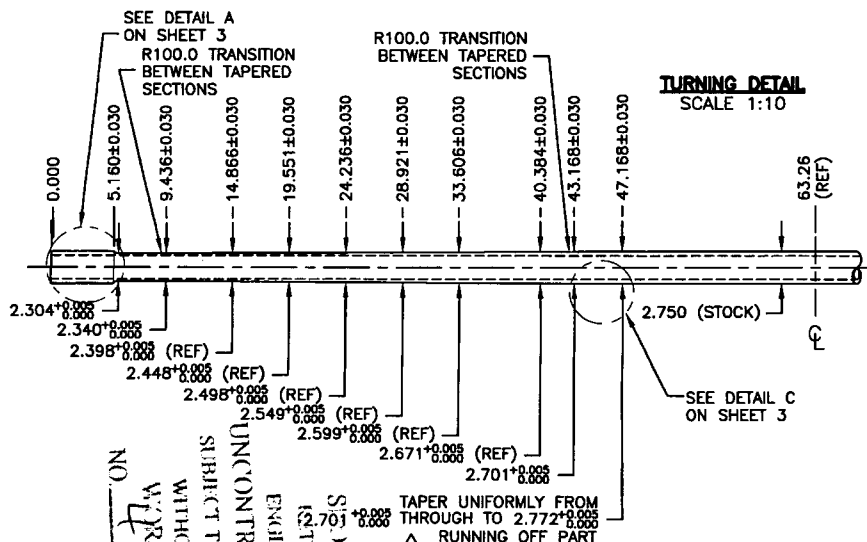
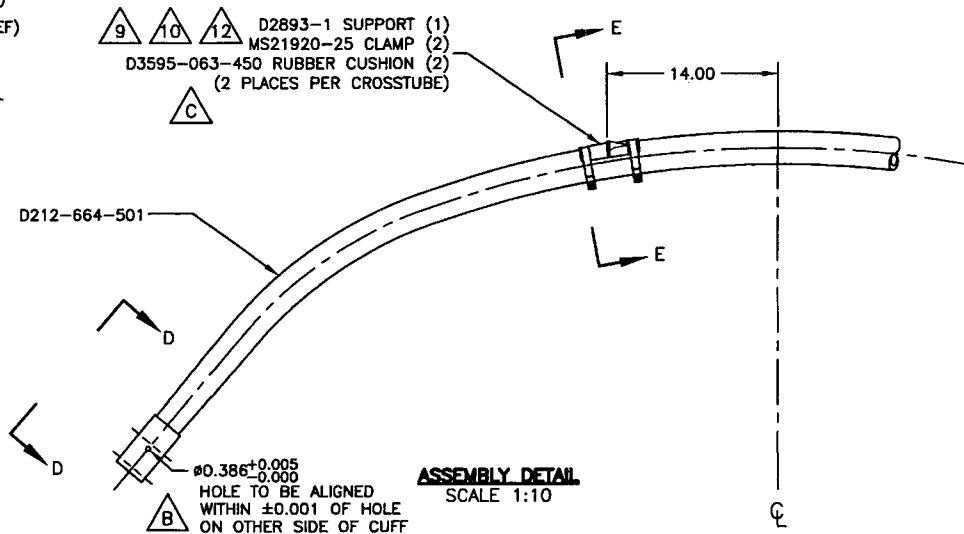
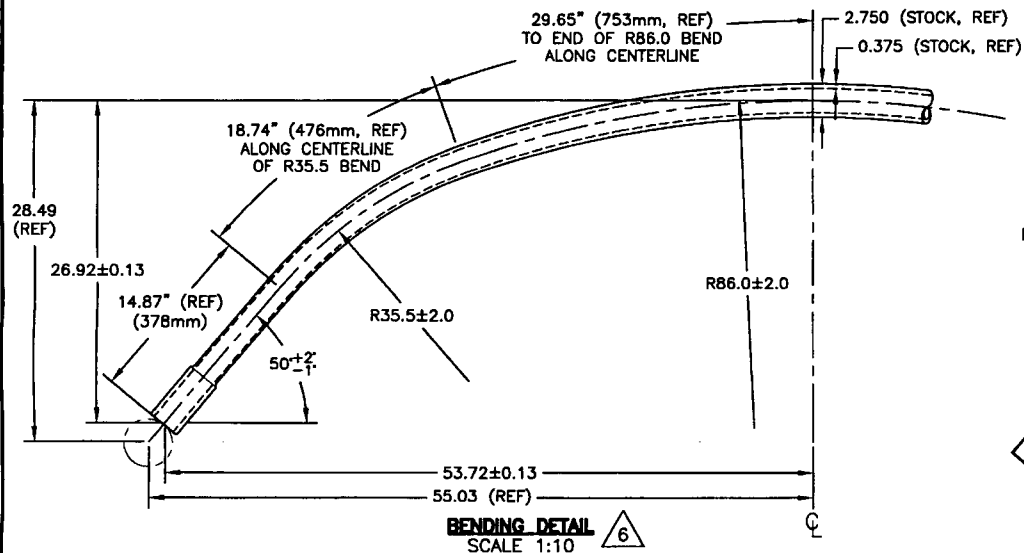
**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY KEY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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07.04.24

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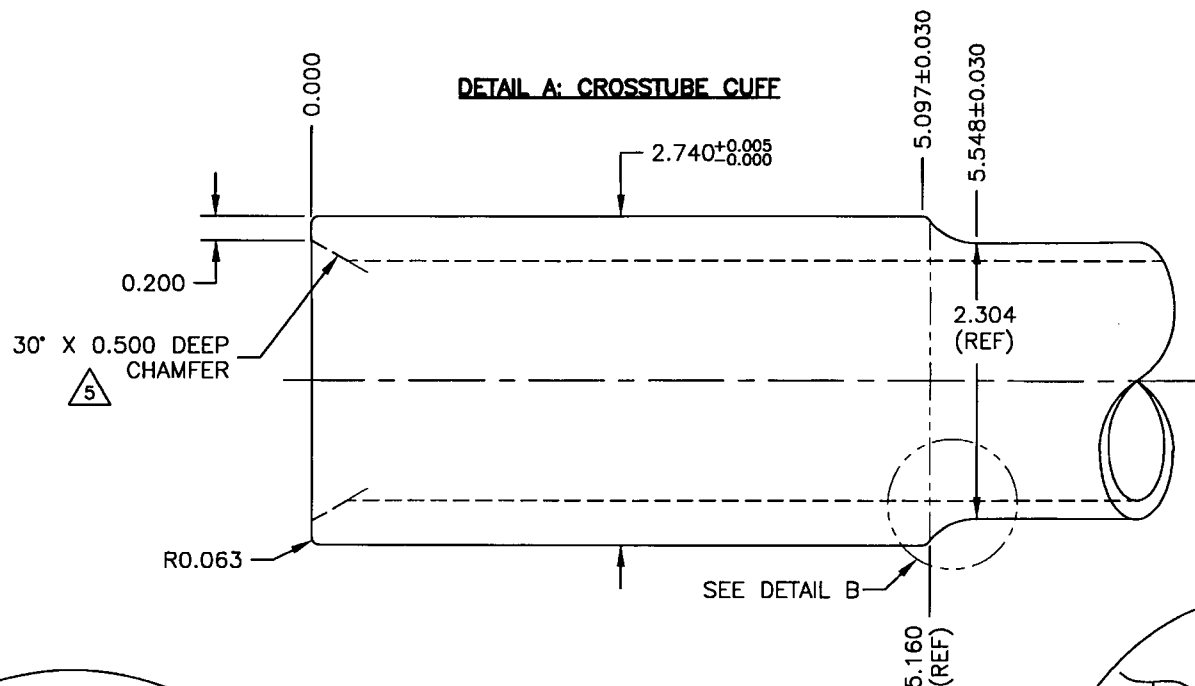
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CHECKED	92	APPROVED	4	DRAWING NO. D212-664-141	REV. C SHEET 2 OF 3
DATE	07.03.08	TITLE	XTUBE ASS'Y (205/212/412 HI FWD)	SCALE	1:10

NO. 47953

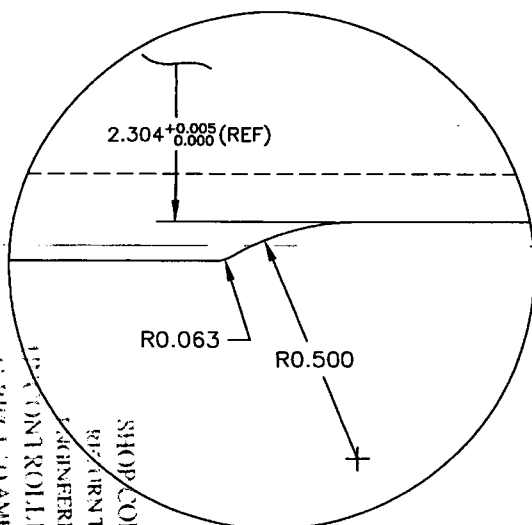
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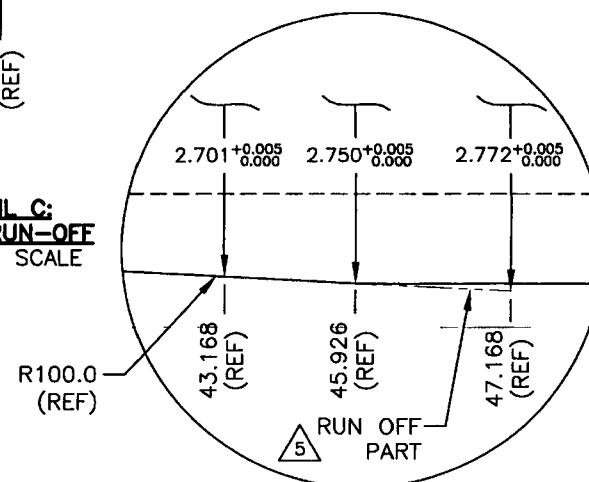
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1**



**DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE**



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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED J	APPROVED JH	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08	TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1	



# LIQUID PENETRANT TEST REPORT

P- 14939

CLIENT	DART AEROSPACE	DATE	MAY 7, 09	PAGE	1	OF	1	
ATTENTION	CHANTEL	ACUREN JOB NO.	188-09-001395	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ABELDEN HARRISBURG, PA K6H 1K7	PO/NO.	8751	WORK LOCATION	UAW SHOP			
PROJECT	F.P.T. ON CROSS TUBES.	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2007			
ITEM(S) EXAMINED								

JOB DESCRIPTION	PROCEDURE NO. LT-XXXX REV./DATE	TECHNIQUE NO. LT-XXXX-XXX REV./DATE
PART NO.	MATERIAL ALUMINUM THICKNESS	
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL	

TEST DETAILS	
METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND MAGNAFLUX	BLACK LIGHT S/N IP65 <input type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup> <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT EL 67 MINIMUM DWELL TIME 45 MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN.	OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	CAL DUE DATE FEB 2010

TEST SURFACE	
SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL	
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F	

RESULTS- ( <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)																
<table border="1"><thead><tr><th>ITEM</th><th>ACCEPT</th><th>REJECT</th></tr></thead><tbody><tr><td>2 - JOB NUMBER</td><td></td><td></td></tr><tr><td>1 - 47370</td><td><input checked="" type="checkbox"/></td><td></td></tr><tr><td>1 - 47752</td><td><input checked="" type="checkbox"/></td><td></td></tr><tr><td>1 - 47753</td><td><input checked="" type="checkbox"/></td><td></td></tr></tbody></table>	ITEM	ACCEPT	REJECT	2 - JOB NUMBER			1 - 47370	<input checked="" type="checkbox"/>		1 - 47752	<input checked="" type="checkbox"/>		1 - 47753	<input checked="" type="checkbox"/>		<p>09 05 08</p>
ITEM	ACCEPT	REJECT														
2 - JOB NUMBER																
1 - 47370	<input checked="" type="checkbox"/>															
1 - 47752	<input checked="" type="checkbox"/>															
1 - 47753	<input checked="" type="checkbox"/>															
THESE THREE ITEMS WERE FOUND ACCEPTABLE																

**Scope of Services**  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

**Standard of Care**  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	MATTHEW MURDOCH
TECHNICIAN (SIGNATURE):	Mike Johnston
NAME (PRINT):	1 <sup>st</sup> TECHNICIAN
CGSB LEVEL II SNT LEVEL	CGSB LEVEL SNT LEVEL
CGSB REG. No 6-066	CGSB REG. No
DTR # E-27913	
REPORT REVIEWED BY:	
NAME	INITIALS

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PINK - TECHNICIAN COPY

GOLD - OFFICE COPY